

SPLIT

Dart Aerospace Ltd.

Date: Friday, 6/25/2007 8:36:55 AM
 User: Kim Johnson

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services		Drawing Name	: WEARPLATE	
Job Number	: 32649-2		Part Number	: D25771	
Estimate Number	: 10288		Drawing Number	: D2577 REV E	
P.O. Number	: N/A		Project Number	: N/A	
This Issue	: 6/25/2007 S.O. No. : N/A		Drawing Revision	: E	
Prsht Rev.	: NC		Material	: N/A	
First Issue	: N/A		Due Date	: 6/12/2007	
Previous Run	: 31212		Qty:	30 Unit: Each	
Written By					
Checked & Approved By					
Comment					
	Est: E	02.09.24 Re-format; Incorporated D2577-101-11 K			
	J/RF				
	est: F	06.09.11	now waterjet	EC	

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description:
1.0	M1010S16GA	1010/1025/A21/6aA SHEET
		Comment: Qty: 0.8474 sf(s)/Unit Total: 25.4205 sf(s) 1010/1025/A21/6aA SHEET
2.0	WATER JET	FLOW WATER JET
		Comment: FLOW WATER JET 1-Cut as per Dwg D2577 (D2577-101 detail) Dwg Rev: E Prog Rev: E
		2-Deburr if necessary
3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
		Comment: INSPECT PARTS AS THEY COME OFF MACHINE
4.0	QC8	SECOND CHECK
		Comment: SECOND CHECK
5.0	BRAKE NC	NC BRAKE
		Comment: NC BRAKE 1-Form on brake as per Dwg D2577 using DT8155 and DT8179 2-Form joggle as per Dwg D2577 using DT8157 3-Identify as D2577-1 4-Deburr if nesasary

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Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: WEARPLATE

Job Number: 32649

Part Number: D25771

Job Number:



Seq. #: Machine Or Operation:

Description:

6.0 QC5

INSPECT WORK TO CURRENT STEP



Counted

Comment: INSPECT WORK TO CURRENT STEP

7.0 LARGE FAB 1

LARGE FABRICATION RESOURCE 1



Comment: LARGE FABRICATION RESOURCE 1

Weld hard surface using DT8308A & DT8308B as per Dwg D2577

Qty Description
A/R 7560 Hardcoat Rod

Batch
M104721

88 07/07/19

Ex

88 07/07/19

8.0 QC9

VISUAL WELDING INSPECTION



(PTO on back)

Comment: VISUAL WELDING INSPECTION

9.0 POWDER COATING

POWDER COATING



M104846



8-

Comment: POWDER COATING

Powder Coat Grey Sandtex (Ref: 4.3.5.6) as per QSI 005 4.3

10.0 QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



87/7/20 8

Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

11.0 PACKAGING 1

PACKAGING RESOURCE #1



8X

Comment: PACKAGING RESOURCE #1

Identify and Stock

Location:

FP-15

m-f 07/07/25

07/07/25

12.0 QC21

FINAL INSPECTION/W/O RELEASE



8

Comment: FINAL INSPECTION/W/O RELEASE

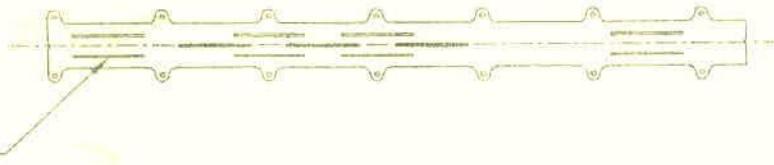
8. 07/07/26

Job Completion



7/07/07/26

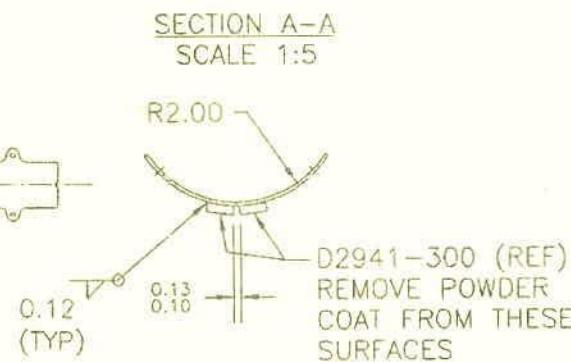
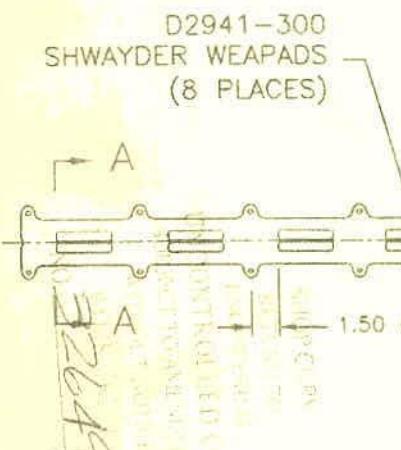
7560 HARDCOAT WELD
4.0 LONG
0.063 TO 0.125 HIGH
(TYP. 11 PLS.)
WELD AFTER BENDING AS
ILLUSTRATED PER DT8308



D2577-1 & D2577-3 WEARSHOE

MAKE FROM D2577-11 AND D2577-13 RESPECTIVELY

FINISH: POWDER COAT GREY (4.3.5.6) PER DART QSI 005 4.3
TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED



D2577-21 & D2577-23 WEARSHOE

MAKE FROM D2577-11 AND D2577-13 RESPECTIVELY

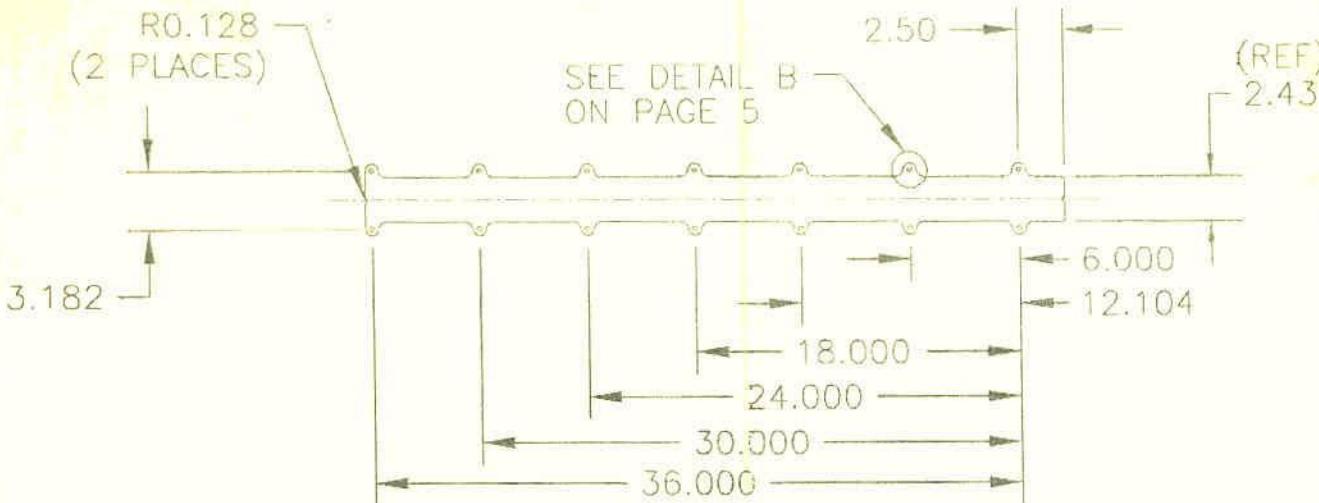
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TO FRANCFS ARF PFR DART QSI 018 UNIFSS OTHERWISE NOTED

RELEASED

DART

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DART
AEROSPACE

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DATE		TITLE	REV. E SH: 1 OF 5 SCALE 1:10	
A		96.09.16	WEARSHOE	NEW ISSUE
B		96.12.04	ADD HARDCOAT WELDS	
C		97.05.30	CHANGE HOLES TO OBOUNDS	
D		98.08.17	CORRECTED DIMENSIONS ON -1 & -3	
E		00.09.22	ADD D2577-101/-11/-13 INCORPORATE DE09176	

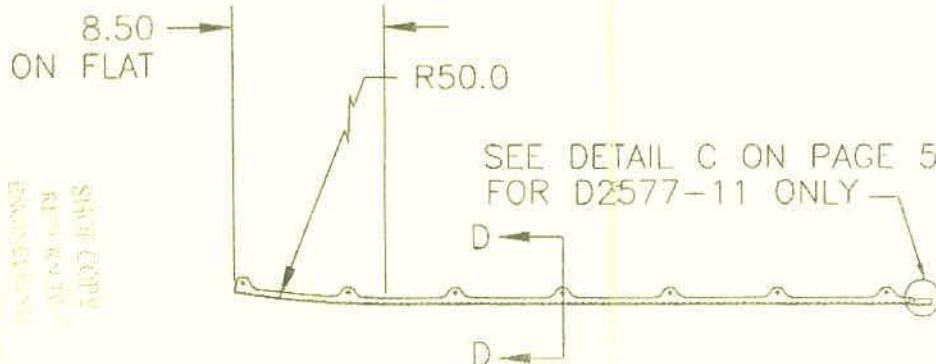


D2577-101 FLAT PATTERN

BREAK ALL SHARP CORNERS 0.010 TO 0.020

MATERIAL: AISI 1010-1025 OR ASTM A36/A366/A569/A570
SERIES STEEL 0.063 THICK

TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED



D2577-11 & D2577-13 LONGITUDINAL BEND

MAKE FROM D2577-101

TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

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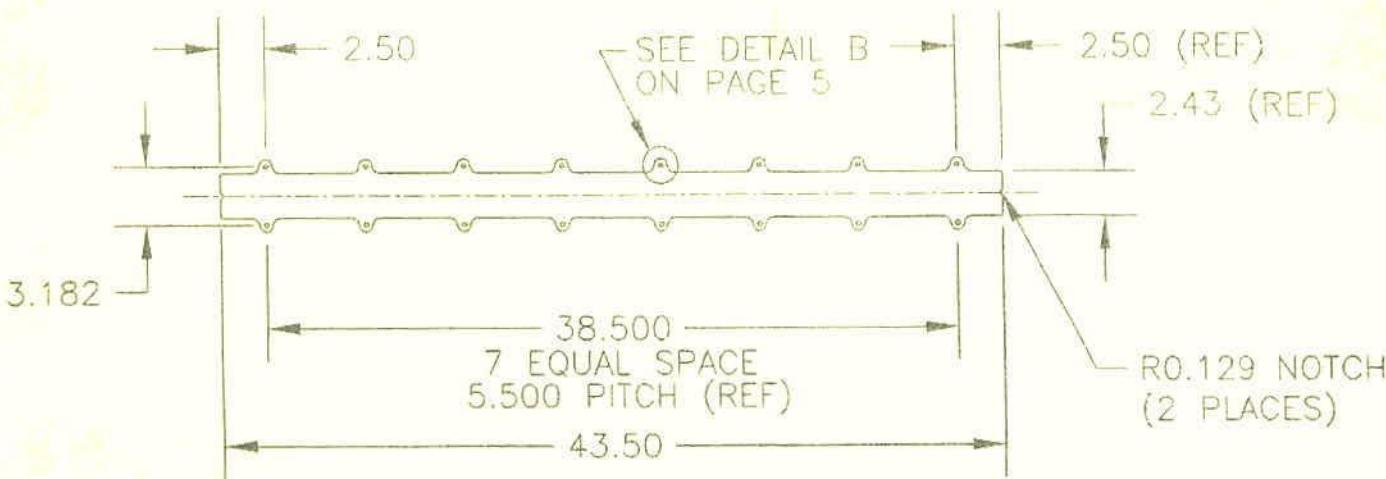


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4	4	DATE 00.09.22
		TITLE WEARSHOE

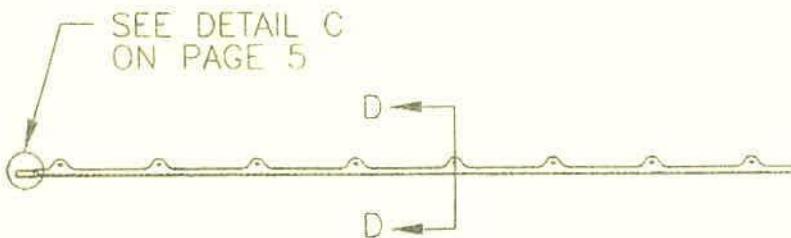
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NO 32649
MATERIAL: AISI 1010-1025 OR ASTM A36/A366/A569/A570
SERIES STEEL 0.063 THICK
UNCONTROLLED DOCUMENT
SUBJECT TO APPROVAL
WHEN ISSUED

D2577-5 FLAT PATTERN



D2577-5 LONGITUDINAL BEND



D2577-5 WEARSHOE

BREAK ALL SHARP CORNERS 0.010 TO 0.020

MATERIAL: AISI 1010-1025 OR ASTM A36/A366/A569/A570
SERIES STEEL 0.063 THICK

FINISH: POWDER COAT GREY (1.3.5.6) PER DART QSI 005 4.3
TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

32649

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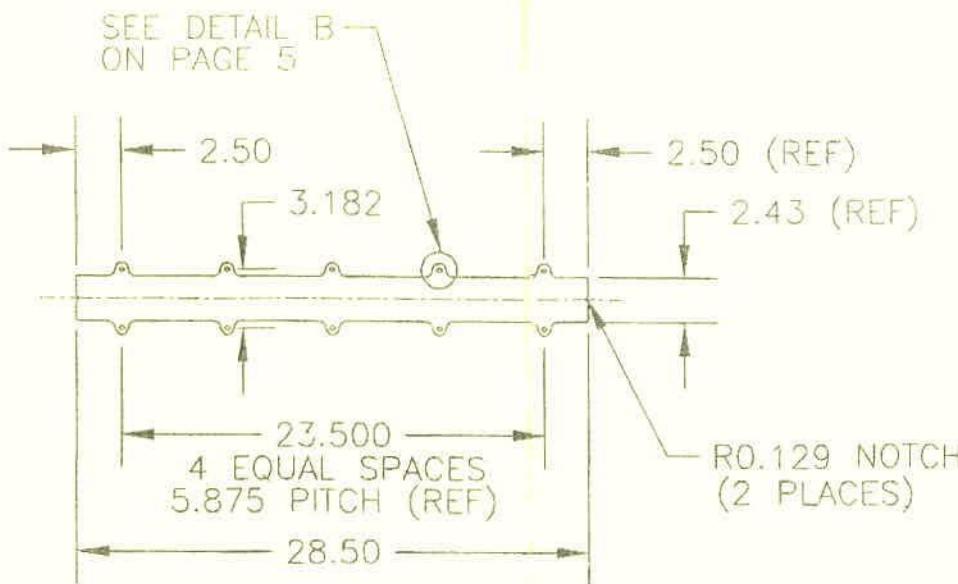
DART

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03/03/01

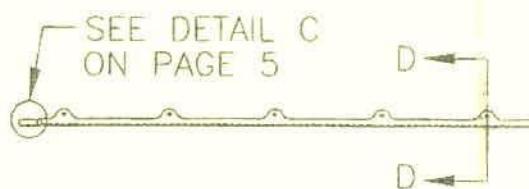
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DATE		SEE 3 OF 5
00.09.22		SCALE 1:10
		TITLE WEARSHOE

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05 01 2004 *MM*

D2577-7 FLAT PATTERN



D2577-7 LONGITUDINAL BEND



D2577-7 WEARSHOE

BREAK ALL SHARP CORNERS 0.010 TO 0.020

MATERIAL AISI 1010-1025 OR ASTM A36/A366/A569/A570

STRENGTH STEEL 0.063 THICK

FINISH: POWDER COAT GREY (4356) PER DART QSI 005 4.3
TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

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		D2577
DATE		TITLE
00.09.22		WEARSHOE

SCALE

REV. C

SET 4 OF 5

1:10

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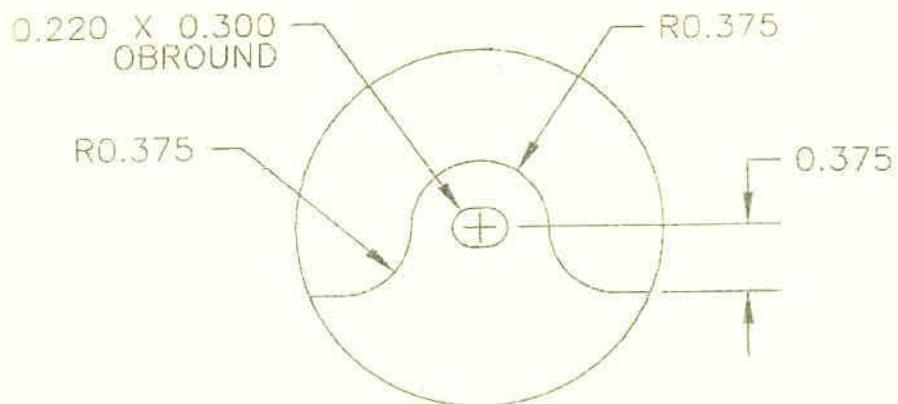


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04/09/2023

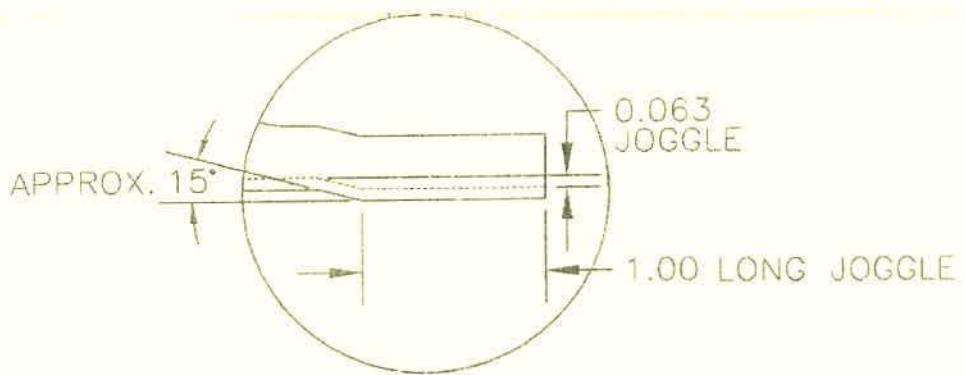
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DATE	TITLE	WEARSHOE	SCALE
00.09.22			1:10

DETAIL B (SCALE 1:1)

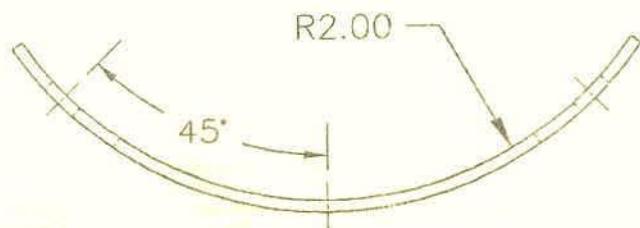
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00.09.22



DETAIL C (SCALE 1:1)



SECTION D-D (SCALE 1:1)



STUDDED
BLIND HOLE
SPLIT HOLE
UNCOMPLETED
SOLID
WELDED
SLOT
NO. 32629

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Work Order: 32649

Description: Clear Plate

Part Number: D2577

Inspector Dwg D2577 Rev 15

Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

First Article Prototype

Inspection Sheet Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
3.182	+/- 0.010	3.190	✓		Vern	
36.000	+/- 0.010	36.000	✓		ST H-T	
30.000	+/- 0.010	30.000	✓		H-T	
24.000	+/- 0.010	24.000	✓		H-T	
18.000	+/- 0.010	18.000	✓		H-T	
12.104	+/- 0.010	12.109	✓		Vern	
6.000	+/- 0.010	6.006	✓		Vern	
2.500	+/- 0.030	2.503	✓		Vern	
2.43	+/- 0.030	2.49	✓		Vern	
0.220	+/- 0.010	0.221	✓		Vern	
0.310	+/- 0.010	0.301	✓		Vern	
0.062	+/- 0.010	0.056	✓		Vern	

540

07/06/14

Edited by:

Date:

Prototype Approval:

卷之三

Changes

Orange Alouettes

NEW ISSUE

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: D2577-1 PAR #: N/A Fault Category: Prod/L.G. NCR: Yes No DQA: Date: 01/07/20
QA: N/C Closed: Date: 07.07.20

NCR: 32649-2		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
01/07/20	1.0	One wear plate scrap Welded on wrong side Side	J 01/07/20	Scrap + destroy	SL 01/07/20	M 01/07/20	J 01/07/20	J 01/07/20
		Wear plate was put on wrong side of jig Weld where not as per dwg - weld was on ^{out} side						

NOTE: Date & initial all entries

